Serial No. 10/593,043

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Amendments To The Claims:

Please amend the claims as shown.

1-7 (canceled)

8. (currently amended) A turbine rotor shaft, comprising:

a middle region consisting of a middle bloc, having a middle region material and a longitudinal axis and having a first end face oriented perpendicular to the longitudinal axis and arranged at an a first end of the middle region and a second end face arranged at a second end of the middle region opposite the first end face;

a first outer region <u>consisting of a first bloc</u>, having a first material and arranged coaxially with the longitudinal axis abutting the first end face of the middle region, <u>comprising a first</u> bearing surface configured to receive a first bearing which mounts the first outer region to the turbine; and

a second outer region <u>consisting of a second bloc</u>, having a second material and arranged coaxially with the longitudinal axis and abutting the second end face of the middle region, <u>comprising a second bearing surface configured to receive a second bearing which mounts the second outer region to the turbine</u>, wherein the middle region material has a higher heat resistance than the first and second materials.

- 9. (previously presented) The turbine shaft as claimed in claim 8, wherein the first and second outer regions are welded to the middle region.
- 10. (previously presented) The turbine shaft as claimed in claim 9, wherein the middle region material is a forging steel having 9 to 12% by weight of chromium and the first and second materials are steels having 1 to 2% by weight of chromium.
- 11. (previously presented) The turbine shaft as claimed in claim 10, wherein the first and second outer region materials are different.

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- 12. (previously presented) The turbine shaft as claimed in claim11, wherein the middle region is exposed to steam at 550°C and 250 bar.
- 13 (previously presented) The turbine shaft as claimed in claim 8, wherein the middle region material is nickel based.
 - 14. (currently amended) A method for manufacturing a turbine shaft, comprising: producing a middle region from a middle bloc of a heat-resistant material;

producing a first outer region from <u>a first bloc of</u> a material that is less heat-resistant than the middle region material, the first outer region comprising a first bearing surface configured to receive a first bearing which mounts the first outer region to a turbine;

producing a second outer region from <u>second bloc of</u> a material that is less heat-resistant than the middle region material, the <u>second outer region comprising a second bearing surface</u> <u>configured to receive a second bearing which mounts the second outer region to the turbine</u>; and welding the first and second outer regions <u>to</u> opposite ends of the middle region.

15. (currently amended) A steam turbine, comprising:

a turbine shaft arranged coaxial with a rotational axis of the turbine wherein the shaft has a middle region consisting of a middle bloc, having a middle region material and first and second end faces oriented perpendicular to the longitudinal axis of the shaft arranged at opposite ends of the middle region,

a first outer region consisting of a first bloc, the first outer region comprising a first bearing surface configured to receive a first bearing which mounts the first outer region to a turbine, the first outer region having a first material and arranged coaxially with the longitudinal axis abutting the first end face of the middle region, and

a second outer region consisting of a second bloc, the second outer region comprising a second bearing surface configured to receive a second bearing which mounts the second outer region to the turbine, the second outer region having a second material and arranged coaxially with the longitudinal axis and abutting the second end face of the middle region wherein the middle region material has a higher heat resistance than the first and second materials;

a plurality of blades attached to the first outer and second outer regions of the turbine shaft;

an inner casing surrounding the turbine shaft; a plurality of vanes attached to an inner surface of the inner casing; and an outer casing that surrounds the inner casing.

- 16 (new) The turbine shaft as claimed in claim 13, wherein the first and second materials are steels having 9 to 12% by weight chromium fraction.
- 17 (new) The turbine shaft as claimed in claim 13, wherein the first and second materials are steels having approximately 3.5% by weight of nickel.
- 18. (new) The turbine shaft as claimed in claim 8, wherein the middle region material is a forging steel having 9 to 12% by weight of chromium and the first and second materials are steels having 3.5% by weight of nickel.